



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D206-667-103TRN
Job Sheet 194383



Part No: D206-667-103TRN

Job Qty: 1 pcs

Part Name: Crosstube Turning Detail



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/1/19

Job Tracking No:

Due Date: 6/7/19

Created By: Jennifer Renwick

Type: Stock

Description:

Note: DWG REV C IPP Rev:A 08-03-06 new issue DD verified by:ec IPP Rev B 08.04.02 removed polish EC verified by DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	DAS Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
100	Mori Seiki TL-40 - 1	1 pcs	6/7/19	6/7/19	0.00	2.10	Mori Seiki TL-40 - 1			66 2019-06-19
110	QC 2	1 pcs	6/7/19	6/7/19	0.00	0.00	QC 2 - 1		9-89	
							QC 2 - 12			
							QC 2 - 14			
							QC 2 - 17			
							QC 2 - 19			
							QC 2 - 2			
							QC 2 - 20			
							QC 2 - 22			
							QC 2 - 23			
							QC 2 - 25			
							QC 2 - 32			
							QC 2 - 33			
							QC 2 - 35			
							QC 2 - 39			
							QC 2 - 4			
							QC 2 - 40			
							QC 2 - 44			
							QC 2 - 45			
							QC 2 - 48			
							QC 2 - 49			
							QC 2 - 50			
							QC 2 - 51			
							QC 2 - 52			
							QC 2 - 57			
							QC 2 - 62			
							QC 2 - 63			
							QC 2 - 8			DAS
							QC 2 - 66			66 2019-06-19
							QC 2 - 64			9-89

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					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	DAS
120	Mori Seiki TL-40 - 1 - B4B	1 pcs	6/7/19	0.00 2.10	Mori Seiki TL-40 - 1 - B4B	66 2019-06-20 9-89
130	QC 2	1 pcs	6/7/19	0.00 0.00	QC 2 - 1	
					QC 2 - 12	
					QC 2 - 14	
					QC 2 - 17	
					QC 2 - 19	
					QC 2 - 2	
					QC 2 - 20	
					QC 2 - 22	
					QC 2 - 23	
					QC 2 - 25	
					QC 2 - 32	
					QC 2 - 33	
					QC 2 - 35	
					QC 2 - 39	
					QC 2 - 4	
					QC 2 - 40	
					QC 2 - 44	
					QC 2 - 45	
					QC 2 - 48	
					QC 2 - 49	
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	DAS
					QC 2 - 66	66 2019-06-20 9-89
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
140	QC 8	1 pcs	6/7/19	0.00 0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	DAS
					QC 8 - 67	67 19-07-24 9-89
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	

				QC 8 - 23		
145	Crosstubes - 2 - B4B	1 pcs	6/7/19	0.00 0.59	Crosstubes - 1 - B4B	BS 7/29/2019
					Crosstubes - 2 - B4B	
					Crosstubes - 3 - B4B	
					Crosstubes - 4 - B4B	
150	Crosstubes - 3 - B4B HAND FINISH	1 pcs	6/7/19	0.00 0.72	Crosstubes - 1 - B4B	AUG 06 2019
					Crosstubes - 2 - B4B	
					Crosstubes - 3 - B4B	
					Crosstubes - 4 - B4B	
160	QC 7	1 pcs	6/7/19	0.00 0.00	QC 7 - 10	DAS 67 19-08-07 9-89
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
170	Packaging 3-1 - Stock - B4B	1 pcs	6/7/19	0.00 0.00	Packaging 3 - 1 - B4B	BS 8/1/2019
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
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				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	1 pcs	6/7/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	DAS AUG 09 2019
				QC 21 - SA - 53	21

Part Op 100 - Mori Seiki TL-40 (Mori Seiki CNC Lathe Large) 1-Fill tube with sand & install plugs DT8534 on both ends as per Descriptions: Folio FA087 2-Turn first side as per Folio FA087 3-Blend transition lines only, **do not sand whole tube**: FOLIO REV: _____ DWG REV: _____ *Use mill bastard file, brush file repeatedly with file card. *Do not use sandpaper coarser than 320 grit.

110 - QC2-1 (QC2- Inspect parts off machine FAI/FAIB) QC2- Inspect parts off machine FAI/FAIB

120 - Mori Seiki TL-40 (Mori Seiki CNC Lathe Large) 1-Turn second side as per Folio FA087 2-File down transition lines smooth. 3-Blend transition lines only, **do not sand whole tube**: *Use mill bastard file, brush file repeatedly with file card. FOLIO REV: _____ DWG REV: _____ *Do not use sandpaper coarser than 320 grit.

130 - QC2-1 (QC2- Inspect parts off machine FAI/FAIB) QC2- Inspect parts off machine FAI/FAIB

140 - QC8 (QC8- Inspect parts - second check) QC8- Inspect parts - second check

145 - Crosstubes-1 (Crosstubes) GRIND ONLY TRANSITION LINES SMOOTH LONGITUDE WAY.

150 - Crosstubes-3 (Crosstubes) 1- PRESSURE WASH X-TUBE INSIDE AND OUT 2- ALODINE AND ACID ETCH X-TUBE INSIDE AND OUT. USE RED SCOTCH BRITE

160 - QC7-1 (QC7-Inspect Chemical Conversion Coat) QC7-Inspect Chemical Conversion Coat

170 - Identify and stock in kanban rack Location: _____

180 - QC21 (QC21- Final Inspection - Work Order Release) QC21- Final Inspection - Work Order Release

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D6002-115	Crosstube Material	1 pcs (1 ea)	100-Mori Seiki TL-40 - 1	F107867

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Mori Seiki TL-40 - 1	D6002-115	1	67	0

Part Specifications				
Specifications could not be found.				

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CANADA
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Container No: S191646



Part: D206-667-103TRN

Job No: 194383

Serial No/Batch: S191646

Revision:

Inspector:

Exp Date:

Instructions:

Date: 06/19/19

①

DART AEROSPACE LTD	Work Order:	194383
Description: Crosstube Assembly (206L High Fwd)	Part Number:	D206-667-143
Inspection Dwg: D206-667-143 Rev: C		Page 1 of 2

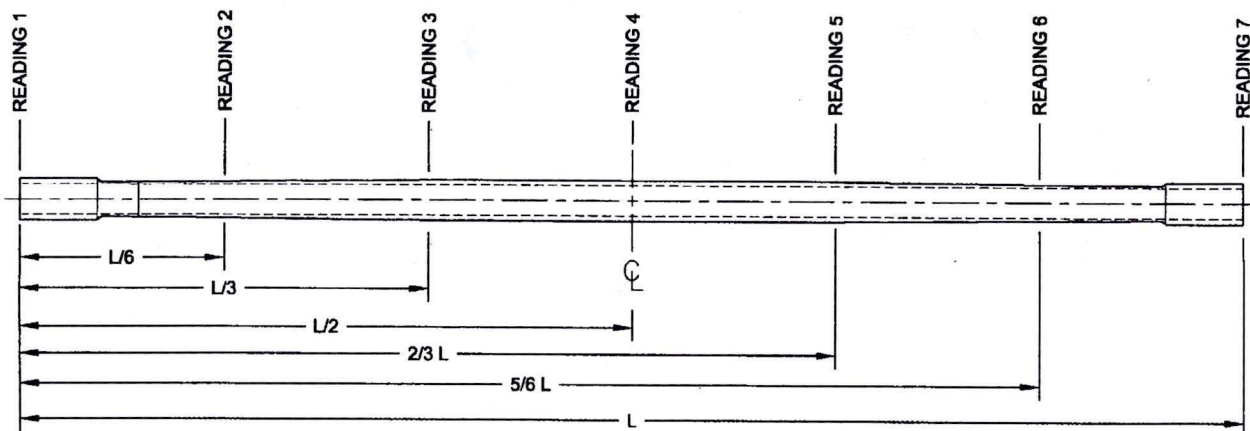
FIRST ARTICLE INSPECTION CHECKLIST

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.240	✓		CNC-04	
	1.982	+0.005/-0.000	1.984	✓		CNC-08	
	2.019	+0.005/-0.000	2.023	✓		CNC-04	
	2.058	+0.005/-0.000	2.063	✓		↓	
	2.097	+0.005/-0.000	2.102	✓			
	2.136	+0.005/-0.000	2.140	✓			
	2.176	+0.005/-0.000	2.181	✓			
	2.201	+0.005/-0.000	2.206	✓			
	0.125	+/-0.010	.123	✓		CNC-08	
	0.400 x 30°	+/-0.010					
	R0.063	+/-0.010	.063	✓		RG	
	R0.500	+/-0.010	.500	✓		"	
	4.438	+/-0.030	4.438	✓		CNC-08	
SIDE B	104.98	+/-0.020	---	---	---	---	---
	2.240	+0.005/-0.000	2.240	✓		CNC-04	
	1.982	+0.005/-0.000	1.984	✓		CNC-08	
	2.019	+0.005/-0.000	2.023	✓		CNC-04	
	2.058	+0.005/-0.000	2.063	✓		↓	
	2.097	+0.005/-0.000	2.102	✓			
	2.136	+0.005/-0.000	2.140	✓			
	2.176	+0.005/-0.000	2.181	✓			
	2.201	+0.005/-0.000	2.206	✓			
	0.125	+/-0.010	.121	✓		CNC-08	
	0.400 x 30°	+/-0.010					
	R0.063	+/-0.010	.063	✓		RG	
	R0.500	+/-0.010	.500	✓		"	
	4.438	+/-0.030	4.439	✓		CNC-08	
	104.984	+/-0.030	104.990	✓		Tape	

①

DART AEROSPACE LTD	Work Order:	199385
Description: Crosstube Assembly (206L High Fwd)	Part Number:	D206-667-143
Inspection Dwg: D206-667-143 Rev: C		Page 2 of 2

WALL THICKNESS MEASUREMENT



Location	WALL THICKNESS MEASUREMENT (IN)				Deviation Δw (max-min)	TOLERANCE
	w1	w2	w3	w4		
READING 1 L= 0"	.226	.249	.262	.243	.036	0.245
READING 2 L= 17.497	.160	.173	.178	.168	.018	
READING 3 L= 34.995	.229	.245	.251	.238	.022	
READING 4 L= 52.492	.237	.253	.262	.250	.025	
READING 5 L= 69.989	.223	.242	.256	.236	.033	
READING 6 L= 87.487	.146	.170	.187	.165	.041	0.167
READING 7 L= 104.984	.227	.252	.258	.238	.031	

0.245 - 0.019

0.166 - 0.020

Acceptable per D6602

Calibration Result

Actual Block Thickness: 100-300

Sitescan 250 Measured Thickness: 100-300

Measured by:	DAS 66	Audited by:	DAS 67	Preliminary Approval:	
Date:	2019-06-20	Date:	9-89	Date:	

Rev	Date	Change	Revised by	Approved
A	04.05.06	New Issue (P/O D206-667-103)	KJ/RF	
B	06.03.09	Dwg Rev updated	KJ/JLM	
C	10.09.13	Dwg Rev updated	KJ	
D	12.06.04	Wall thickness form added	KJ	

Item	Qty -143	Part Number	Description
1	X	D206-667-143	CROSSTUBE ASSEMBLY (206L HIGH FWD)
2	1	D6002-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2891-1	SUPPORT
6	4	D3595-063-395	RUBBER CUSHION
7	4	MS21920-20	CLAMP (OR MS21920-21)
8	14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
9	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2
10	2	AN742D36	CLAMP
11	2	MS9165-05	ANGLE BRACKET
12	2	MS21042L3	NUT (OR MS21042-3)
13	2	MS27039-1-08	SCREW
14	4	NAS1149C0332R	WASHER (OR AN960C10L)

GENERAL NOTES:

- MATERIAL: MANUFACTURED FROM D6002-115
FINISHED LENGTH = 104.98±0.020
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-143" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- WEIGHT: 15.5 lbs
- PART IS SYMMETRIC ABOUT CENTERLINE.
- RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- TO INSTALL D2891-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSSTUBE SUPPORTS.
- EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- TORQUE CLAMPS 80 TO 100 IN.-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.
- MASK AREA UNDER CLAMP PRIOR TO PAINTING.
- SEAL EDGES WHERE AN742D36 CLAMP MEETS WITH THE CROSSTUBE USING SIKAFLEX-241/-291 OR MIL-S-8802 CLASS B2 OR PROSEAL 890 SEALANT.
- PERFORM RESISTANCE CHECK TO ENSURE MAX RESISTANCE IS 10 MILLIOHMS.

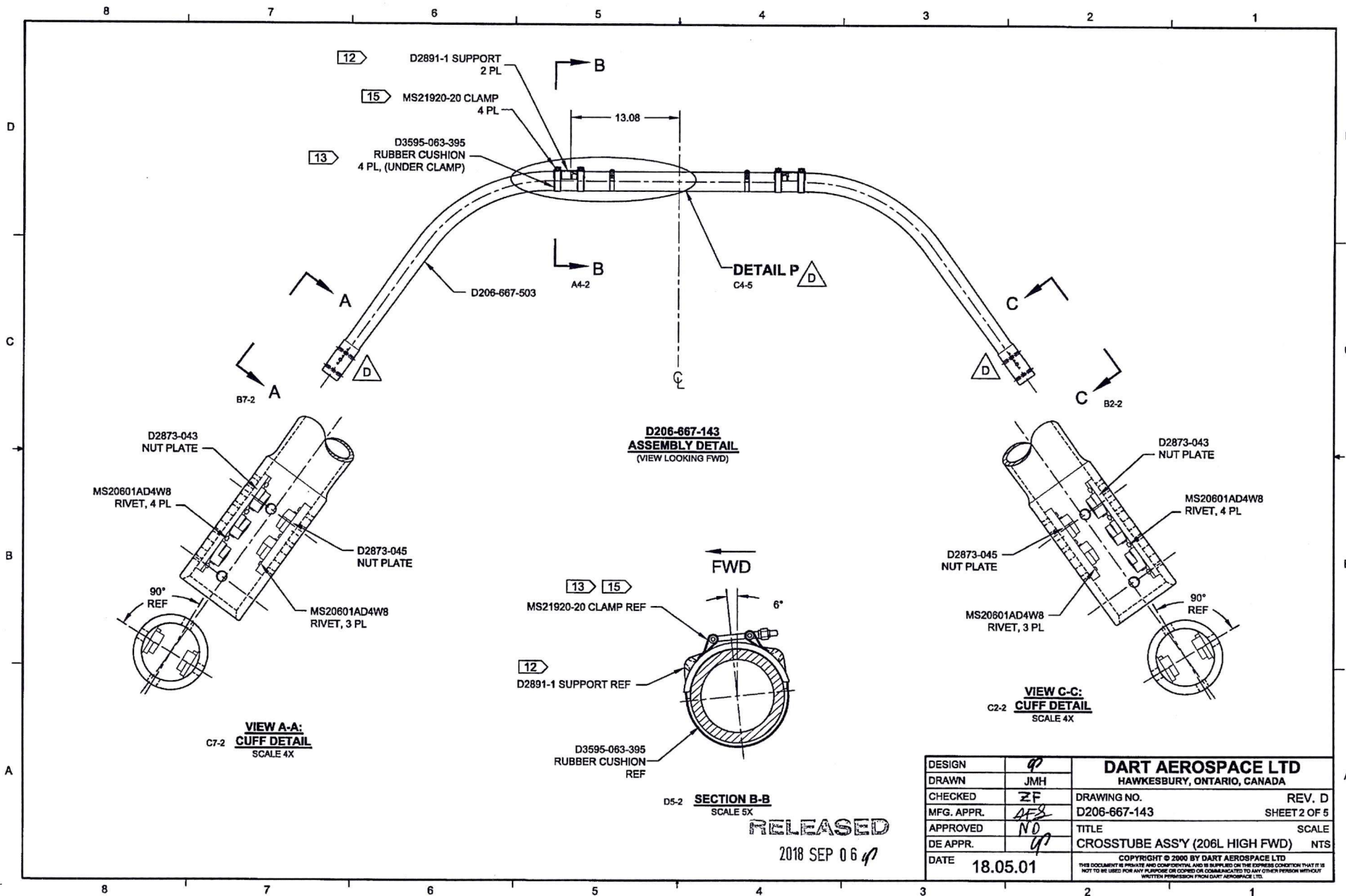
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 194383

MAY 1 2019

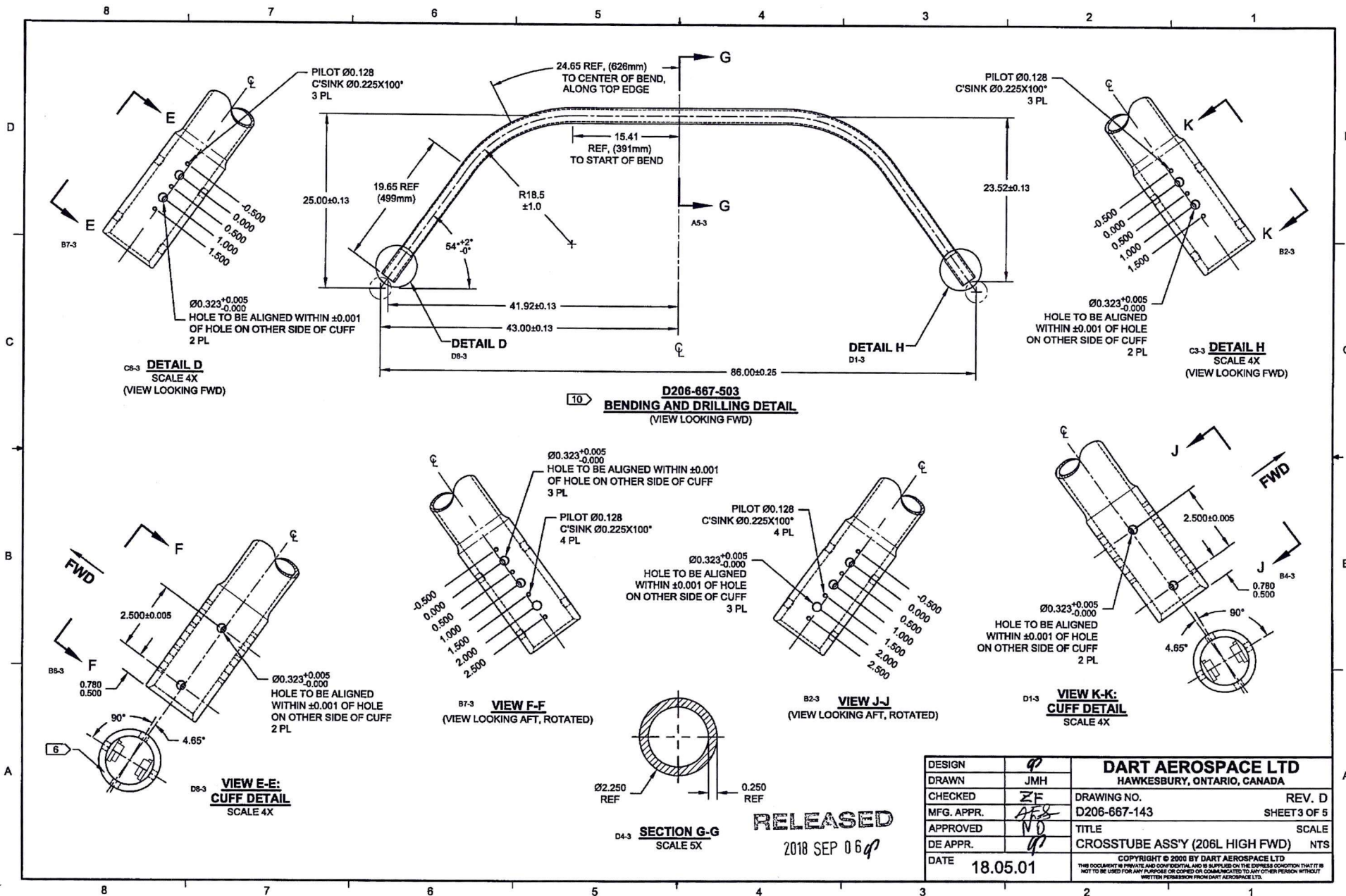
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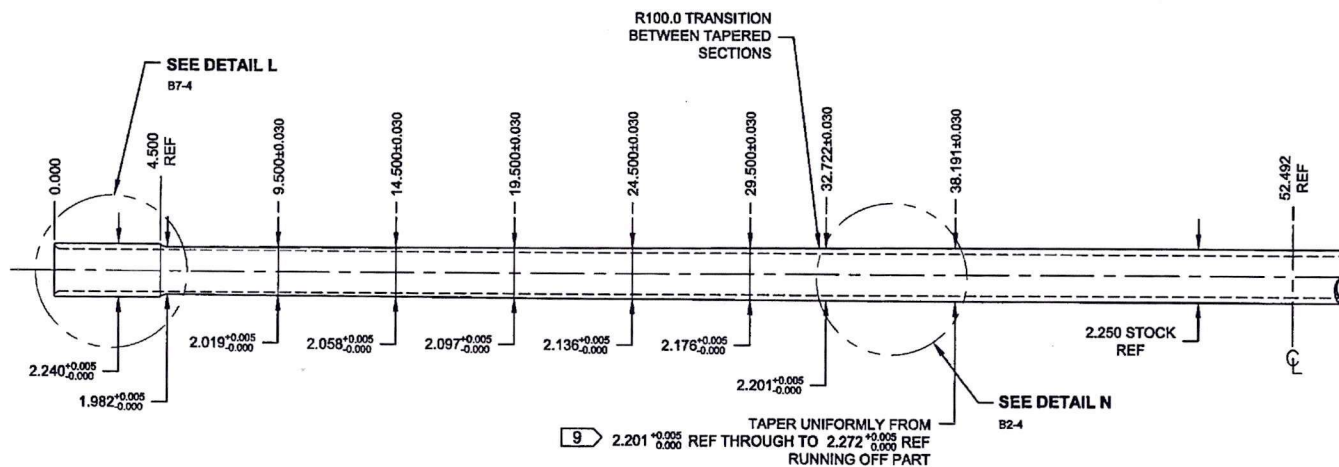
2018 SEP 06
EN 14-777

D	REVISE SHEET 2 ASSEMBLY DETAIL HOLE PATTERN PER CAR18-221. UPDATE PARTS LIST AND GENERAL NOTES 12 & 15 TO INCORPORATE DEO C-1. ADD ITEMS 10-14 TO PARTS LIST, ADD GENERAL NOTES 16-18 AND ADD SHEET 5 TO INCORPORATE DEO C-2.	JMH	18.05.01
C	REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-395 WAS D2856-400-894 (ZN D6-2 & A5-2); REMOVED REF. & ADD TOLERANCE (ZN D3-3, C4-3, C5-3); RELOCATED FLAG #6 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
B	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUDTUBES	PH	05.07.26
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN	JP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JMH	DRAWING NO.	REV. D
CHECKED	ZF	D206-667-143	SHEET 1 OF 5
MFG. APPR.	AFB	TITLE	SCALE
APPROVED	NO	CROSSTUBE ASS'Y (206L HIGH FWD)	NTS
DE APPR.	JP	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	18.05.01		

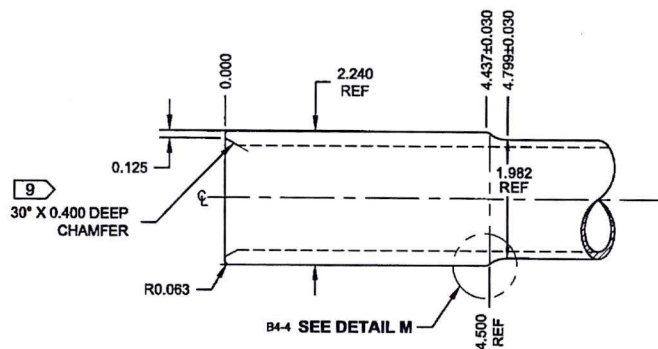


DESIGN	47	DART AEROSPACE LTD	
DRAWN	JMH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ZF	DRAWING NO.	REV. D
MFG. APPR.	AFB	D206-667-143	SHEET 2 OF 5
APPROVED	ND	TITLE	SCALE
DE APPR.	47	CROSSTUBE ASS'Y (206L HIGH FWD)	NTS
DATE	18.05.01	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
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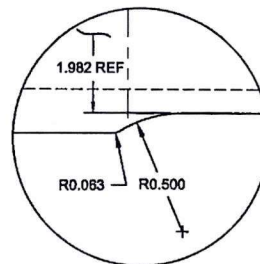




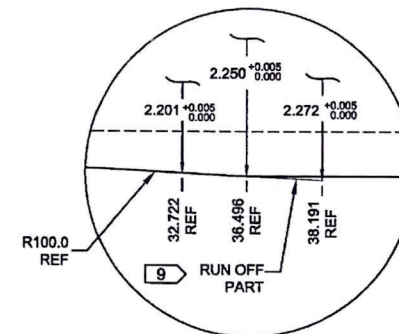
TURNING DETAIL



D7-4 **DETAIL L:**
CROSSTUBE CUFF
NOT TO SCALE



A8-4 **DETAIL M:**
CUFF TRANSITION
NOT TO SCALE

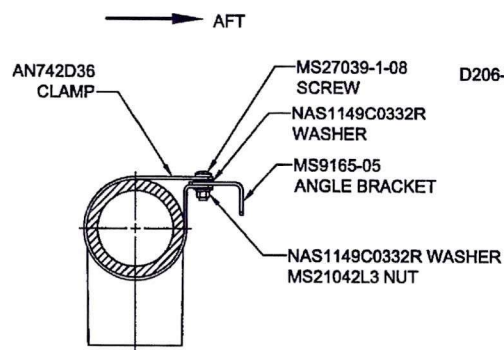


C4-4 **DETAIL N:**
TAPER RUN-OFF
NOT TO SCALE

RELEASED

2018 SEP 06

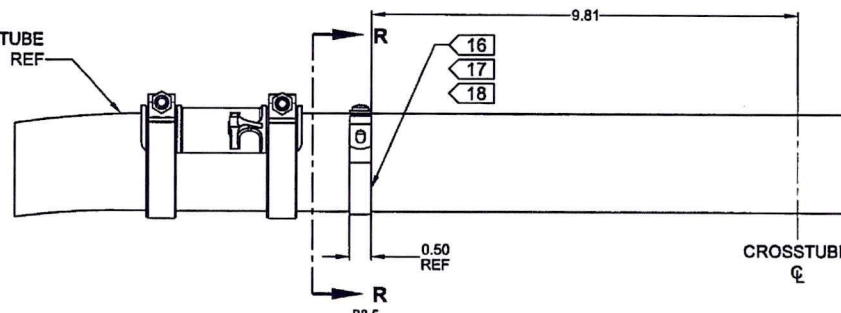
DESIGN	JP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JMH		
CHECKED	ZF	DRAWING NO.	REV. D
MFG. APPR.	AFS	D206-667-143	SHEET 4 OF 5
APPROVED	NO	TITLE	SCALE
DE APPR.	JP	CROSSTUBE ASS'Y (206L HIGH FWD)	NTS
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C4-5 **SECTION R-R**



D206-667-503 CROSSTUBE
REF



D5-2 **DETAIL P**
BONDING STRAP INSTALLATION 2 PL



RELEASED

2018 SEP 06

DESIGN	9P	DART AEROSPACE LTD	
DRAWN	JMH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ZF	DRAWING NO.	REV. D
MFG. APPR.	AFB	D206-667-143	SHEET 5 OF 5
APPROVED	NB	TITLE	SCALE
DE APPR.	9P	CROSSTUBE ASS'Y (206L HIGH FWD)	NTS
DATE	18.05.01	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :	MRB (QSI042)		
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					